

Work Order ID 55815

Tuesday, February 02, 2010 1:20:47 PM

Page 1

Item ID: D3463-5

Accept

Setup Start

Revision ID:

Stop

Item Name: End Cap

Start Date: 2/3/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 2/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-22*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3463

☐ Dwg Rev: *B*

☐ Prog Rev: *B*

☐ 2-

Deburr if necessary

304.063

B 10-2-3

9/10/02/03

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-2-3

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ 8/10/02/03

(+12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Page 2

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Start Date: 2/3/2010 Start Qty: 6.00

Required Date: 2/12/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

10-2-4

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/04

MF

10-2-4

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NOTE: Date & initial all entries

Picklist Print

Tuesday, February 02, 2010 1:20:47 PM

Page 1

Work Order ID: 55815



Parent Item: D3463-5



Parent Item Name: End Cap

Start Date: 2/3/2010

Required Date: 2/12/2010

Comments: IPP REV. A 05.11.18 NEW ISSUE EC
IPP Rev:B Now on Waterjet 06-06-15 JLM

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304S16GA | | Purchased | No | | | 100 | sf | 204.6899 | 0.0884 | .2 | | |



304/316 Sheet .063

HB 10-2-3

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

204.6898737

106860

8.0295

111924

25.1689737

112442

29.8865

113295

141.6049

113295



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NOTE: Date & initial all entries

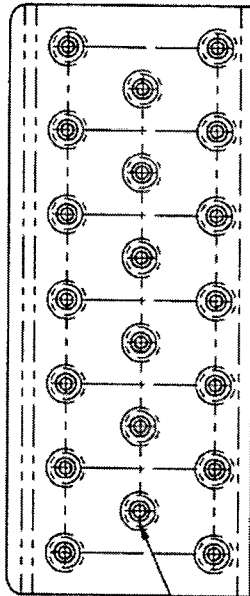
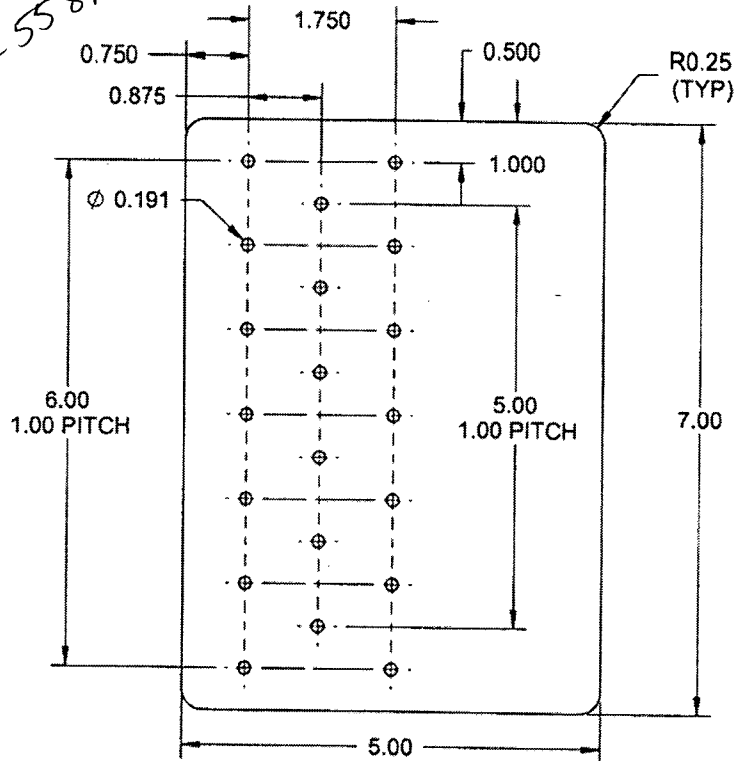
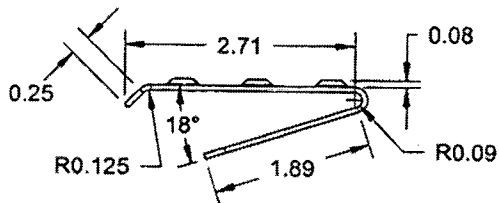
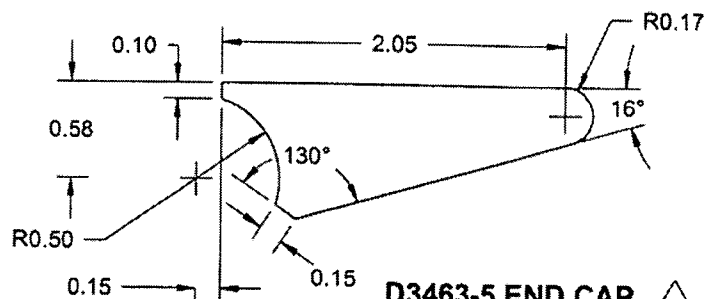
DART

| | | | |
|-------------------------|-------------------------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 4 OF 4 |
| DATE 05.12.05 | TITLE STEP WELDMENT | | SCALE 1:2 |

RELEASED

05.12.09 #

#55815

**FORM USING
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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